



Dart Aerospace Ltd.
1270 Aberdeen St
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D4931-3 Job Sheet 189914



DAS
21
9-89

Part No: D4931-3

Job Qty: 10 pcs

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 3/4/19

Created By: Dara Macdonald

Type: ~~SOLD~~ STOCK

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	3/4/19	3/4/19	0.00	9.90	Doosan - 1		2019-03-20 PMT
110	QC 2	10 pcs	3/4/19	3/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		2019-03-20 PMT
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

DAS
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DAS
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DART
AEROSPACE
Container No: S164286
Part: D4931-3
Job No: 189914
Serial No/Batch: S164286
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 03/20/19

				QC 2 - 8	
112	Conventional Mill - 1 - B4B	10 pcs	3/4/19	0.00 3.82	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
115	QC 2	10 pcs	3/4/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
120	QC 8	10 pcs	3/4/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
130	Packaging 3-2 - Stock - B4B	10 pcs	3/4/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	ST127
				Packaging 3 - 28 - B4B	MAR 27 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAB
140 QC 21 - SA	10 pcs	3/4/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
Part Op 100 - Doosan Lathe Machine as per folio FB210 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 112 - (Manufacture as per dwg) DRILL HOLES AS PER REQUIRED 115 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					

00000 REV A

MAR 27 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	1.5000 ft (.15 ea) .176	100-Doosan - 1	5018010 USED 2.112

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	2	16	0

Part Specifications	
Specifications could not be found.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: EAPS P2 Engine Fitting		Part Number:	D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.059				
M.O.W.	Maj: 1.0995 Min: 1.0938	1.098				
0.13 x 45°	+/-0.030 x +/-0.5°	0.131 x 45				
Ø0.063	+0.004/-0.001	0.062				
0.08	+/-0.030	0.072				
0.906	+/-0.010	0.908				
0.13	+/-0.030	0.1305				
0.25	+/-0.030	0.2505				
0.938	+/-0.010	0.942				
1.927	+/-0.010	1.928				
0.250	+/-0.010	0.246				
0.424	+/-0.010	0.419				
0.315	+/-0.010	0.3155				
0.185	+/-0.010	0.182				
37°	+/-0.5°	37				
0.33	+/-0.030	0.337				
34°	+/-0.5°	34.2°				
0.532	+/-0.010	0.530	✓		Visual JVD5	
1.063	+/-0.010	1.0595				
0.594	+/-0.010	0.594	✓		"	
0.791	+/-0.010	0.790	✓		"	
1.188	+/-0.010	1.187	✓		"	
1.582	+/-0.010	1.580				

Measured by: PMF	Audited by: <i>amf</i>	Preliminary Approval:
Date: 2019-03-20	Date: 19/03/24	Date:
Rev	Date	Change
A	14.06.24	New Issue
Revised by KJ		Approved <i>[Signature]</i>